



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4419-3
Job Sheet 167936



Part No: D4419-3

Job Qty: 10 ea

Part Name: Aft Support Plate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/8/17

Job Tracking No:

Due Date: 11/24/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		11/23/17	0.00	0.00	Start Up Waterjet1		SC
100	Waterjet	10 pcs		11/24/17	0.00	2.11	Waterjet1		SC
110	QC	10 pcs		11/24/17	0.00	0.00	QC2		SC
120	QC	10 pcs		11/24/17	0.00	0.00	QC8		SC
130	Packaging	10 pcs		11/24/17	0.00	0.00	Packaging3		SC
140	QC21-SA	10 Ea		11/24/17	0.00	0.00	QC21		SC

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304S11GA	3	141	0	0

Part Specifications

Specifications could not be found.

Plex 11/8/17 11:17 AM dart.poulin.mario

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐			
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Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval																					
Description Work Order Deviation S012967 Aft Support Plate Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com				position 				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																			
Environment Design Doc/Data Equip/Tooling Handling/Pre Material Internal Transport Tribal Knowledge LOA Substation Past Expiry Date Misidentified		PART NO: D4419-3 Revision: Start up Operation Operation: Change No: Rushing Product Improvement Process Improvement Manufacturing Process Past Due		Countersink Heat Treat Wave/Twist in Tube Marks/Chatter OTHER :		ORY <table style="width:100%; border: none;"> <tr> <td style="width:50%;">☐ Power Loss/Surge</td> <td style="width:50%;">☐ Positioned Wrong</td> </tr> <tr> <td>☐ Folio/Program</td> <td>☐ Outside Dimensions</td> </tr> <tr> <td>☐ Grain</td> <td>☐ Over/Under tolerance</td> </tr> <tr> <td>☐ Weld</td> <td>☐ Part Incorrect</td> </tr> <tr> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Out of Sequence</td> <td>☐ Part Moved</td> </tr> <tr> <td>☐ Off-set</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Fit/Function</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Misaligned/off center</td> <td>☐ Turning Sequence</td> </tr> </table>		☐ Power Loss/Surge	☐ Positioned Wrong	☐ Folio/Program	☐ Outside Dimensions	☐ Grain	☐ Over/Under tolerance	☐ Weld	☐ Part Incorrect	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Out of Sequence	☐ Part Moved	☐ Off-set	☐ Drawing	☐ Mislabeled	☐ Finish	☐ Fit/Function	☐ Misread	☐ Misaligned/off center	☐ Turning Sequence
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DART AEROSPACE LTD		Work Order:	167936
Description: Aft Support Plate		Part Number:	D4419-3
Inspection Dwg: D4419 Rev: A		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0,129			VDR-Ø	
Ø0.191	+0.005/-0.001	0,191			Tape	
Ø0.250	+0.005/-0.001	0,250				
Ø0.53	+0.008/-0.001	0,529				
5.55	+/-0.030	5,555				
5.27	+/-0.030	5,274				
4.25	+/-0.030	4,256				
2.80	+/-0.030	2,81				
0.40	+/-0.030	0,406				
3.83	+/-0.030	3,837				
5.56	+/-0.030	5,563				
6.26	+/-0.030	6,266				
7.14	+/-0.030	7,148				
7.73	+/-0.030	7,735				
0.31	+/-0.030	0,313				
0.38	+/-0.030	0,387				
0.750	+/-0.010	0,751				
1.53	+/-0.030	1,537				
0.390	+/-0.010	0,392				
0.450	+/-0.010	0,453				
1.67	+/-0.030	1,679				
10.55	+/-0.030	10,556				
8.00	+/-0.030	8,01				
6.02	+/-0.030	6,027				
1.10	+/-0.030	1,106				
1.20	+/-0.030	1,205				
0.50	+/-0.030	0,509				
1.500	+/-0.010	1,501				
0.60	+/-0.030	0,608				
2.300	+/-0.010	2,301				
0.63	+/-0.030	0,64				
0.991	+/-0.010	0,990				
0.440	+/-0.010	0,441				

